Work Order ID 57748 April 14, 2010 11:37:34 AM							1					Page 1
Revision ID: Item Name:	D3749-1 Hinge Half 14/04/2010 22/04/2010	Start Qty: 10.0 Req'd Qty: 10.0			Cust Item I				Setup	Start Stop		
Reference: Approvals:	Process Pla	n:/	Date:///	/// Tooling: SPC (Y/N):		ate:			Run	Start Stop		######################################
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		Reject Tumber	Insp. Stamp
Draw Nbr D3749	Rev Rev	ision Nbr A								1		
Waterjet FLOW CNC Waterje			per Dwg D3749 □Dw necessary	0.00 g Rev:□Prog Rev:	□2-		730	B wolo4	10-4	-19	(B)	
QC Quality Control		QC2- Inspect parts of	f machine FAI/FAIB	0.00				_B	10-4.	49		·
120 		QC8- Inspect parts - s	econd check	0.00 0.00 Sw	loulay			(418)	,		

Quality Control

Dart Aerospac	e Ltd
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W/O:			W	ORK ORDER	CHANGES			···		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									1 100 Mg/	
·										
•										
Part No	<u> </u>	DAD #.	Foult Cot		- Alc	.				
Part No: PAR #:										
NOD				OER NON-CO					Date:	
NCR:	T		WORK ORL			E (NCH				
DATE	STEP	Description of NC Section A	Initial	Corrective Acti Action De		Sign &	Verific		Approval	Approval
		GGGGGTTA	Chief Eng	Chief		Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 57748

April 14, 2010 11:37:34 AM

Required Date: 22/04/2010



Page 2

Item ID:

D3749-1

Accept

Setup Start



Revision ID:

Item Name:

Hinge Half

Start Date: 14/04/2010

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: Date:_

Draw

Rev.

Run

Start

Stop



Number Stamp

Sequence ID/

Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Date:_____ SPC (Y/N):

Set Up/ **Run Hours**

0.00

0.00

SB 10/01/21

Stop

Reject

Reject

Qty



Insp.

Memo

Memo

Memo

Form as per Dwg D3749 using CNC Brake

Accept

Qty

Plan

Code

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging

Packaging

Identify as per dwg & Stock Location Steve

0.00

0.00

10-4-21

									,				
W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
							<u> </u>						
		PAR #:	Fault Cate	ult Category: NCR: Yes No DQA: Date:									
Resolution:			Disposition	n:	_ QA: N/C (QA: N/C Closed: Date:							
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)							
DATE	STEP	Description of NC		on B	Verific	cation	Approval	Approval					
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector				
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Work Order ID 57748

April 14, 2010 11:37:34 AM



Page 3

Item ID:

D3749-1

Revision ID:

Item Name: Hinge Half

Start Date:

14/04/2010

Start Qty: 10.00

Required Date: 22/04/2010



Accept



Setup Start





Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

QC:

Operation

Date:_____

Date: Tooling:

SPC (Y/N):

Draw

Number

Cust Item ID:

Customer:

Date:

Draw

Rev.

Plan

Code

Date:

Run

Accept

Qty

Start

Reject

Qty



Stop

Reject

Number Stamp

Insp.

Sequence ID/

Work Center ID

160

QC

Description QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours**

0.00

0.00

Quality Control

MG 10-4-22

	-							,						
W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector						
		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:									
			Dispositio	n:	QA: N/C Cld	Closed: Date:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)								
DATE	STEP	Description of NC		ion B	Verification	on Approval	Approval							
	JIL.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector						
		·												
				1										

April 14, 2010 11:37:38 AM

Work Order ID: 57748

Parent Item:

D3749-1

Parent Item Name:

Hinge Half

IPP Rev:A IPP Rev B

08-02-05

new issue DD verified by:EC 08-02-27 rev.A as per ecn 1139 DD verified by:

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/

Item Name

Comments:

M304S11GA

Replacement Mfg/ Item ID Purch

Purchased

Primary Bin Item Location No

Last Location

Route Seq ID 100

Unit of Measure sf

Qty on Hand 25.3100

Loc Code

Remaining Qty Qty To Pick Issued 0.1968 .36

Date Issued

Status

图10-4-19

304/316 0.125 Sheet

Warehouse Loc Oty Location Main Warehouse MAT19 25.31 112663 25.31

112663



									*				
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	٨:	Date:					
Resolution:			Dispositio	n:	QA: N/C Cld	sed:							
NCR:		•	WORK ORD	ER NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC		on B	ation	Approval	Approval						
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector				
								:					

DART AEROSPACE LTD	Work Order: ら7746
Description: 山人子 リンのモ	Part Number: 03749-(
Inspection Dwg.D3749-(, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

1	rawing mension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
Ø	.648	100 400.	601,	*			
	.337	4- 010	333	8			
	.375	4010	,376	**			
	3.61	7/010	3,608	No.			
	.125	T00	,130	*			
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Measured by:	汉	Audited by:	Prototype Approval:	
	10-4-19	Date: (0(04))	Date:	
L				

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

0 0

D3749-1 HINGE HALF

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 37748

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC M304S11GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

D

6) IDENTIFICATION: N/A 7) WEIGHT: 0.09 lbs

Α	NEW IS	SUE		AJS	08.02.01		
REV.			DESCRIPTION	BY	DATE		
DESIG	V	AJS	DART AEROSPACE LTD				
DRAW	N .	485	HAWKESBURY, ONTARIO, CANADA				
CHECK	ED	. UE	DRAWING NO. R				
MFG. A	PPR.	MO	D3749		SHEET 1 OF 2		
APPRO	VED	NA .	TITLE		SCALE		
DE APPR.			HINGE HALF		NTS		
DATE 08.02.01			THIS DOCUMENT OF STREET OF SOME BY DART ALTROSPACE LTD THIS DOCUMENT OF PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CUTTED IS CONPITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED ON COMMINISCATED TO ANY OTHER PERSON WITHOUT MINISTER PERSONS THOSE ANY FOR DART A REPORT ALT. TO				

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W/O:	W/O:		WORK ORDER CHANGES									
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Resolution:								Date: _				
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DATE	STEP	Description of NC	In its of	Corrective Action Section B Initial Action Description Si								
		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Approval Chief Eng	Approval QC Inspector			
			à 									

8 D 1.25 R0.16 TYP REF **− 1.140 - - -** - 0.335 0.375 R0.25 Ø0.098 -BEND LINE-— 1.30 *—* D3749-1F FLAT PATTERN W/057748 D3749-1 HINGE HALF DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN 43.5 DRAWN DRAWING NO. CHECKED REV. A D3749 MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE HINGE HALF

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NOT TO BE USED FOR ANY PRIMED OF COMED OF COMMISSIONATION TO THE PRIVATE OF THE PRIVATE DE APPR. DATE 08.02.01

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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:					
			Disposition:			A: N/C Closed:				
NCR:			WORK OR	DER NON-CONFORM	IANCE (NCR			O	
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verificat			Approval	Approval
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